

Date: Tuesday, 08/04/2008 4:54:59 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE FITTING
Job Number : 38465	
Estimate Number : 12299	
P.O. Number :	Part Number : D3488041
This Issue : 08/04/2008 S.O. No. :	Drawing Number : D3488 / DSK101
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : B / D
Previous Run : 36234	Material :
Written By :	Due Date : 06/05/2008
Checked & Approved By : <u>JD 08.4.09</u>	Qty: <u>11</u> Um: Each
Comment : Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: 38101

20 08/04/15

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA625

2-Deburr

20 08/04/15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/04/15

(11)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA625 & Dwg D3488

2-Deburr

JL 08/03/13

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/03/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:54:59 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38465

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.8 08/05/15 (11)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/05/15 30 min 15/05/2008 S.245 11.05

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107925 M-L 08/05/15 #1 321.1 F #2 B38465 F #3 #4 D3488041 F

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15 X11

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

* Qty Part Number Description Batch
4 ALS-71032-225 Insert M100489 JJ

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

JJ 08-05-15 (X11)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/15 (X11)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-22

JJ 08-05-15 (X11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:54:59 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38465

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38465
Description: Blade Fitting, RH		Part Number:	D3488-2
Inspection Dwg: D3488	Rev: B	Page 1 of 1	

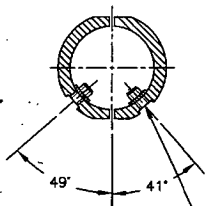
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.128	✓			
2.620	+/-0.010	2.620	✓			
0.793	+/-0.010	.802	✓			
1.351	+/-0.010	1.343	✓			
1.317	+/-0.010	1.316	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.805	✓			
Ø0.508	+0.006/-0.001	.510	✓			
R0.062	+/-0.010	.062	✓			
1.500	+/-0.010	1.500	✓			
8.000	+0.030/-0.000	8.015	✓			
11.18	+/-0.030	11.178	✓			
Ø0.484	+0.005/-0.001	.4835	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.15	✓			
3.070	+/-0.010	3.07	✓			
0.590	+/-0.010	.590	✓			
0.125	+/-0.010	.121	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.500	✓			
Ø0.297	+0.005/-0.000	.300	✓			
Ø0.430	+/-0.010	.430	✓			
0.100	+/-0.010	.100	✓			

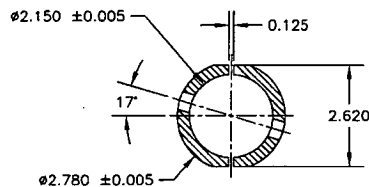
Measured by: JP/JL	Audited by: L.F.	Prototype Approval:	N/A
Date: 08/05/13	Date: 08/05/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	JP



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

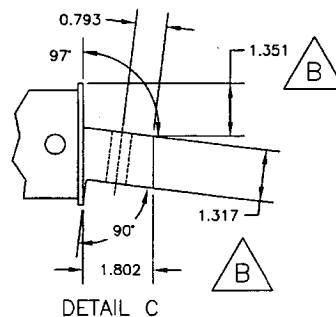
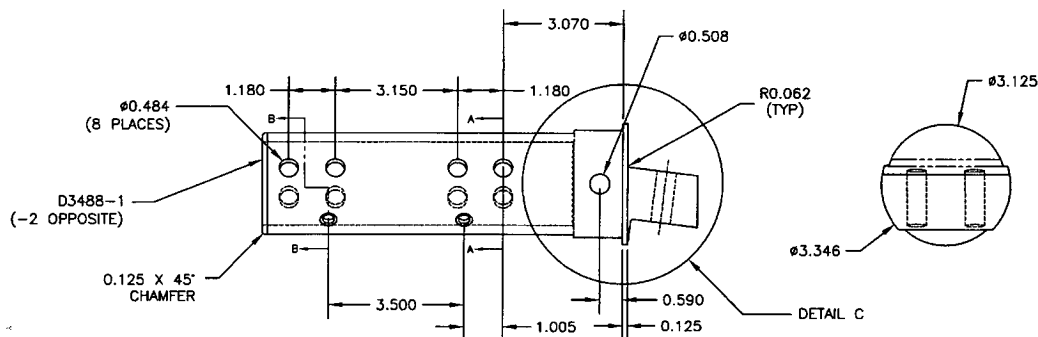
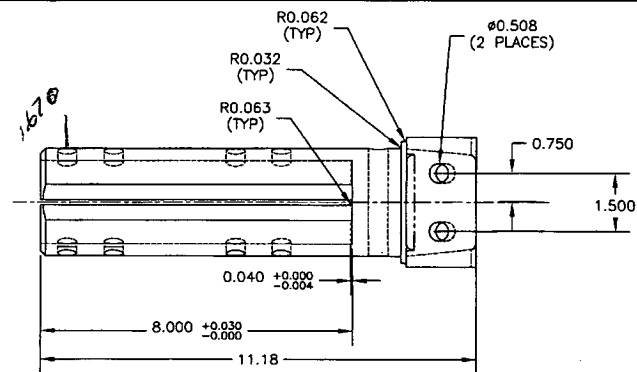
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 38465



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06-03-07 PH
PER DS
ELN #739

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3488
		REV. B
		SHEET 1 OF 1
		SCALE 1:3

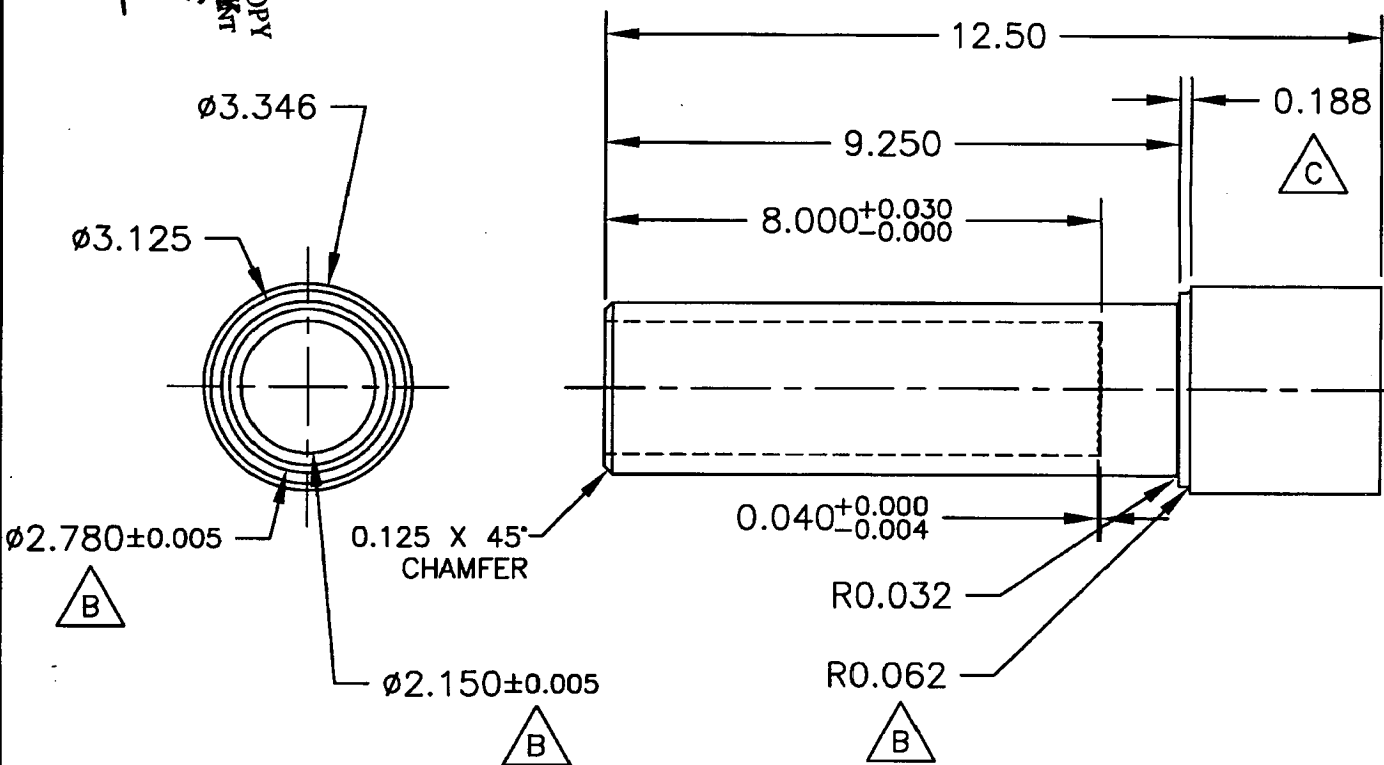
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DART

06.05.09

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	REV. D
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
PH	PH	DSK 101	SCALE
DATE	TITLE		
06.05.09	D3488-1/-2 TURNING DETAIL	1:3	
A	05.12.21	NEW ISSUE	
B	06.03.02	ADD TOLERANCES AND RADIUS	
C	06.04.17	0.188 WAS 0.125	
D	06.05.09	REMOVE DIAMETER FOR CHAMFER	



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 38465